








Date: 11/29/2005 7:09:26 PM  
 User: acelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 25060	
Estimate Number : 10036	Part Number : D6101013
P.O. Number : N/A	Drawing Number : D6101 REV A
This Issue : 11/29/2005 S.O. No. : N/A	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : A
First Issue : N/A	Material : N/A
Previous Run : N/A	Due Date : 11/29/2005
Written By : <u>RET REV 01/05/04 AP</u>	Qty: 20 Um: Each
Checked & Approved By : <u>SEE ABOVE USER</u>	
Comment : Created By Auto Work Order!!* Late - Some of the material cannot be made in time.	
Additional Product	
Job Number: 	
Seq. #:	Description :
1.0 PG	PURCHASING
	
Comment: PURCHASING Issue P/O: <u>00000202</u> <u>05/12/02</u> a) Description: Alluminum billet b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000) c) Tolerance on all dimensions are +0.030/-0.000" d) Grain direction along 10.100" length e) Material: 7075-T7351 (QQ-A-250/12) f) Material certification required	
Tools:	
2.0 PACKAGING 1	PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	
Tools:	
3.0 QC6	DIMENSIONAL CHECK
	
Comment: DIMENSIONAL CHECK Ensure Material certification comply to Dwg D6101	
Tools:	

W/O:		WORK ORDER CHANGES					
STEP	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 26/02/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services  
Drawing Name: SADDLE BILLET

Job Number: 25060  
Part Number: D6101013

Job Number: 

Seq. #: Machine Or Operation: Description :

4.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: CNC

PC 06.03.16 20

Tools: 5.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL  
Inspection Level 21

Tools: 545 06/02/16 (20) 706/02/16 (50)

Job Completion 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# PECHINEY ROLLED PRODUCTS

COPPER & BRASS SALES, INC.  
5 STERLING DRIVE  
WALLINGFORD CT

06492

## CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164 USA

COPPER AND BRASS SALES  
P.O. BOX 5116  
SOUTHFIELD MI

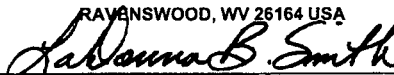
48086

COPPER&BR

E66101 1512

INCLUSION

SERIAL#: 20060125E66101 2

CUSTOMER PURCHASE ORDER NO. & ITEM <b>CH3606</b>				PECHINEY ORDER NO. <b>235-311437</b>		<b>CERTIFICATION</b> "Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." <b>PECHINEY ROLLED PRODUCTS</b> P.O. BOX 68 RAVENSWOOD, WV 26164 USA  LADONNA B. SMITH - LABORATORY MANAGER	
ALLOY <b>7075</b>	CLAD. <b>00</b>	TEMPER <b>T7351</b>	GAUGE <b>2.50000</b>	WIDTH <b>48.500</b>	LENGTH <b>144.500</b>		
ITEM ORDERED <b>MOLD PLATE-DIST GE SPEC PLATE, SAWED MILL</b>							
CUSTOMER SPECIFICATION <b>AMS-QQ-A-250/12</b>							
PART NUMBER <b>091557-9</b>		B/L NUMBER <b>M6936</b>		DATE SHIPPED <b>01/25/06</b>			
WEIGHT SHIPPED <b>7,240</b>		NO. OF PIECES <b>4</b>		GOVT. CONTRACT NO.			

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IAC										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX									
486401			ACTUAL CHEMICAL COMPOSITION																
			SI=0.08 FE=0.17 CU= 1.6 MN=0.06 MG= 2.6 CR=0.19 ZN= 5.5 TI=0.02																
			OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																
			THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTE																
			APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE.																
			THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON																
			THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																
			CHEMISTRY BY OES: ARKSPARK																
			CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																
			WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																			
"END OF CERTIFICATION"																			
C H E M C O M P	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
		ALUMINUM REMAINDER																	

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RAVENSWOOD, WV 26164 USA

COPPER AND BRASS SALES  
P.O. BOX 5116  
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COPPER&BR

E66101 1512

INCLUSION

SERIAL#: 20060125E66101 1

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**PECHINEY ROLLED PRODUCTS**

P.O. BOX 68

RAVENSWOOD, WV 26164 USA

*LaDonna B. Smith*  
LaDONNA B. SMITH - LABORATORY MANAGER

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IAC										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX									
486401	LT	2	***** T7351 69.6	70.6	57.8	59.5	***** 11.5	11.5	39.8	40.1									
<p>-----</p> <p>ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS</p> <p>-----</p> <p>MIL-STD-2154 100%SONIC TESTED MINUS DEAD ZONE CLASS A</p> <p>ALSO CONFORMS TO BSS 7055 CL A SONIC</p> <p>ALSO CONFORMS TO MMS159J, AMS 4078E</p>																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			

# COPPER AND BRASS SALES

## MATERIAL TYPE

### ALUMINUM ALLOYS WITH LOW BERYLLIUM

#### PRODUCT DESIGNATION

2014 2024 2224 2324 7050 7075 7150 7175 7475  
ALUMEC 89 ALUMEC 99 QC-7

## "WARNING"

SMALL CHIPS, FINE TURNINGS AND DUST MAY IGNITE READILY. EXPLOSION POTENTIAL MAY BE PRESENT WHEN: DUST OR FINES ARE DISPERSED IN THE AIR; FINE, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH CERTAIN METAL OXIDES; OR, CHIPS, FINES, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH WATER OR MOISTURE. KEEP AWAY FROM IGNITION SOURCE. USE EXPLOSION-PROOF VENTILATION. KEEP MATERIAL DRY.

THIS PRODUCT CONTAINS BERYLLIUM AND COPPER. INHALING BERYLLIUM DUST OR FUMES MAY CAUSE CHRONIC BERYLLIUM DISEASE (CBD), A SERIOUS CHRONIC LUNG DISEASE IN SOME INDIVIDUALS. BERYLLIUM IS A CANCER HAZARD; OVER TIME CBD AND CANCER CAN BE FATAL, TARGET ORGAN IS PRIMARILY THE LUNG. INHALING LARGE AMOUNTS OF COPPER, MAGNESIUM OXIDE, MANGANESE OXIDE, AND ZINC OXIDE FUMES OR DUST MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS. CHRONIC OVEREXPOSURE TO COPPER MAY CAUSE THICKENING OF THE SKIN; AND SKIN, TEETH, AND HAIR DISCOLORATION. CHRONIC OVEREXPOSURE TO MANGANESE DUST CAN CAUSE CENTRAL NERVOUS SYSTEM DAMAGE, SCARRING OF THE LUNGS AND REPRODUCTIVE HARM IN MALES. TARGET ORGAN IS PRIMARILY THE LUNG, BUT REPEATED HIGH EXPOSURE CAN ALSO AFFECT THE LIVER. CHRONIC OVEREXPOSURE TO IRON OXIDE DUST/FUME MAY CAUSE LUNG SIDEROSIS. CHRONIC OVEREXPOSURE TO SILICON DUST CAN CAUSE CHRONIC BRONCHITIS. OVEREXPOSURE TO AMORPHOUS SILICA CAN CAUSE DRYING OF THE MUCOUS MEMBRANES OF THE EYES, NOSE, AND THROAT.

THIS PRODUCT ALSO CONTAINS NICKEL AND CHROMIUM COMPOUNDS. INHALATION OF NICKEL DUST OR FUME MAY RESULT IN INFLAMMATION OF THE RESPIRATORY TRACT AND CAUSE NASAL AND/OR LUNG CANCER. NICKEL HAS BEEN IDENTIFIED AS A POTENTIAL HUMAN CARCINOGEN. EXPOSURE TO CHROMIUM DUST OR FUME MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS AND KIDNEY AND LIVER DAMAGE. UNDER HIGH TEMPERATURES, HEXAVALENT CHROMIUM MAY BE PRODUCED, IF IN THE INSOLUBLE FORM, IT IS A CONFIRMED HUMAN CARCINOGEN. (CALIFORNIA PROPOSITION 65).

IF COATED WITH OIL, MAY CAUSE SKIN IRRITATION/DERMATITIS BY CONTACT. WELDING FUME IS LISTED AS A POSSIBLE CARCINOGENIC TO HUMANS.

READ THE ALUMINUM/ALUMINUM ALLOYS MATERIAL SAFETY DATA SHEET(MSDS) ON FILE WITH YOUR EMPLOYER BEFORE WORKING WITH THIS MATERIAL

- \* If processing or recycling produces particulate, use exhaust ventilation or other controls designed to prevent exposure to workers. Examples of such activities include melting, welding, grinding, abrasive sawing, sanding and polishing. Any activity which abrades the surface of this material can generate airborne particulate. Use respiratory protection (P100, quantitative fit testing required) if exposures exceed the permissible limits.
- \* The Occupational Safety and Health Administration (OSHA) have set mandatory limits on occupational exposures.
- \* Aluminum, in solid form and as contained in finished products presents no special health risk.
- \* Sold for manufacturing purposes only. This product can be recycled; contact your sales representative.

The Occupational Safety and Health Administration require employers to provide training in the proper use of this product.

For additional information, call or write to Copper and Brass Sales, 22355 West Eleven Mile Road, Southfield, MI 48034, telephone 248-233-5600, or visit our web site @ [www.copperandbrass.com](http://www.copperandbrass.com).